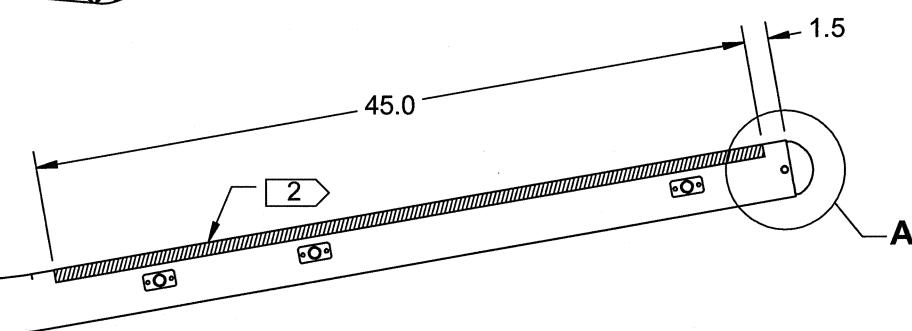
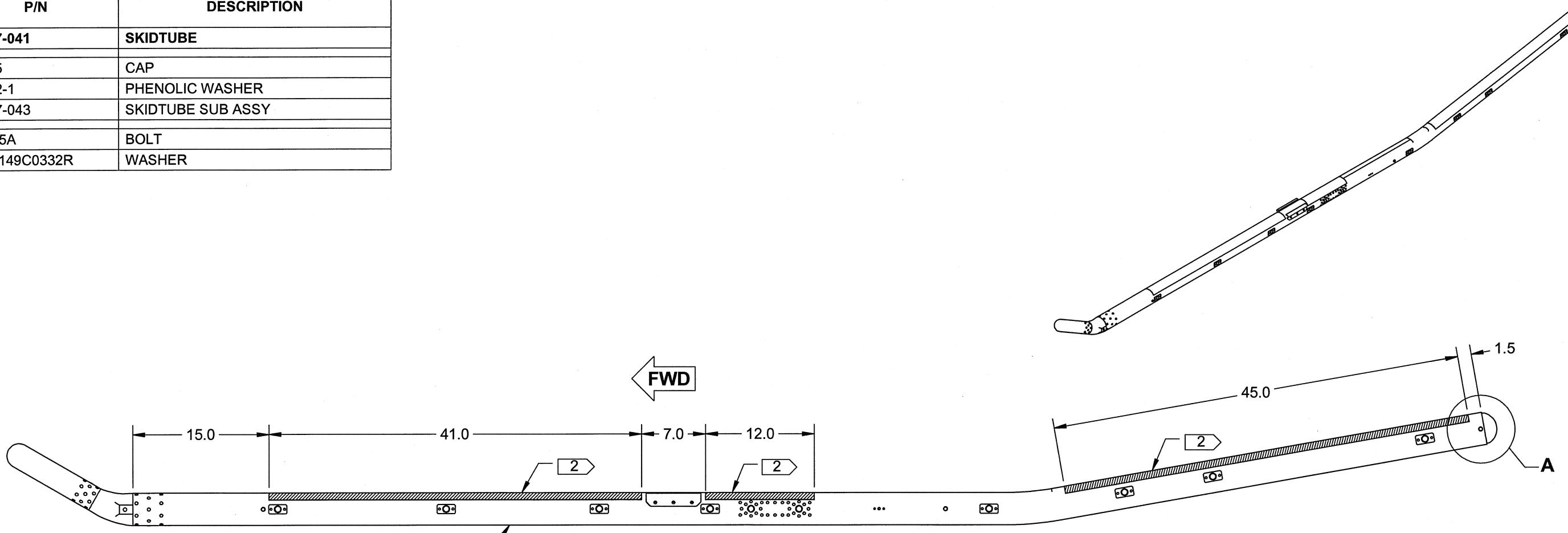


QTY -041	P/N	DESCRIPTION
X	D5657-041	SKIDTUBE
1	D2965	CAP
2	D3672-1	PHENOLIC WASHER
1	D5657-043	SKIDTUBE SUB ASSY
2	AN3C5A	BOLT
2	NAS1149C0332R	WASHER



DETAIL A
SCALE 4X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) PER DART QSI 005 4.4
IN LOCATIONS SHOWN TO 1.00 ABOVE CENTERLINE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N "D5657-041" AND S/N PER DART QSI 044 6.4
ON INNER RADIUS OF AFT END OF TUBE BEFORE INSTALLING CAP
- 7) WEIGHT: 38.0 lbs
- 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 SEALANT
- 9) WET INSTALL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 SEALANT

RELEASED
2019 SEP 10 NO
ECM14-890

APPROVED

A	NEW ISSUE	ZF	18.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	MW		
CHECKED	ZF		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS		
DATE	18.11.30		

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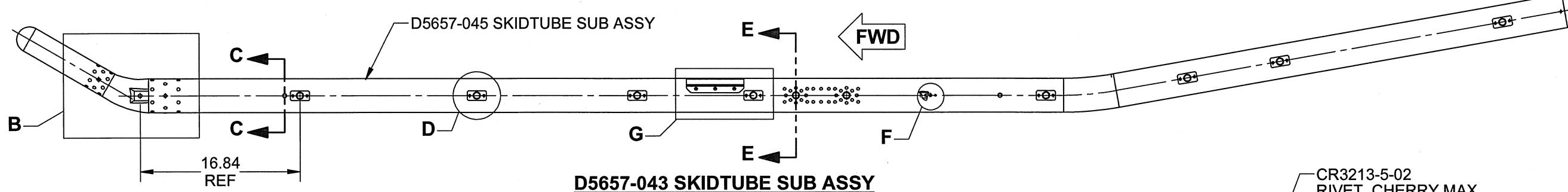
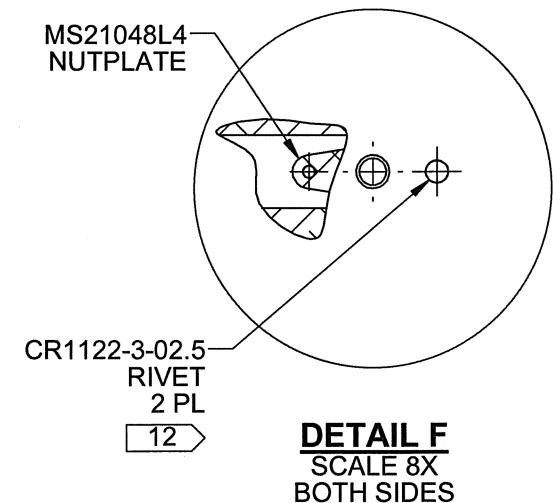
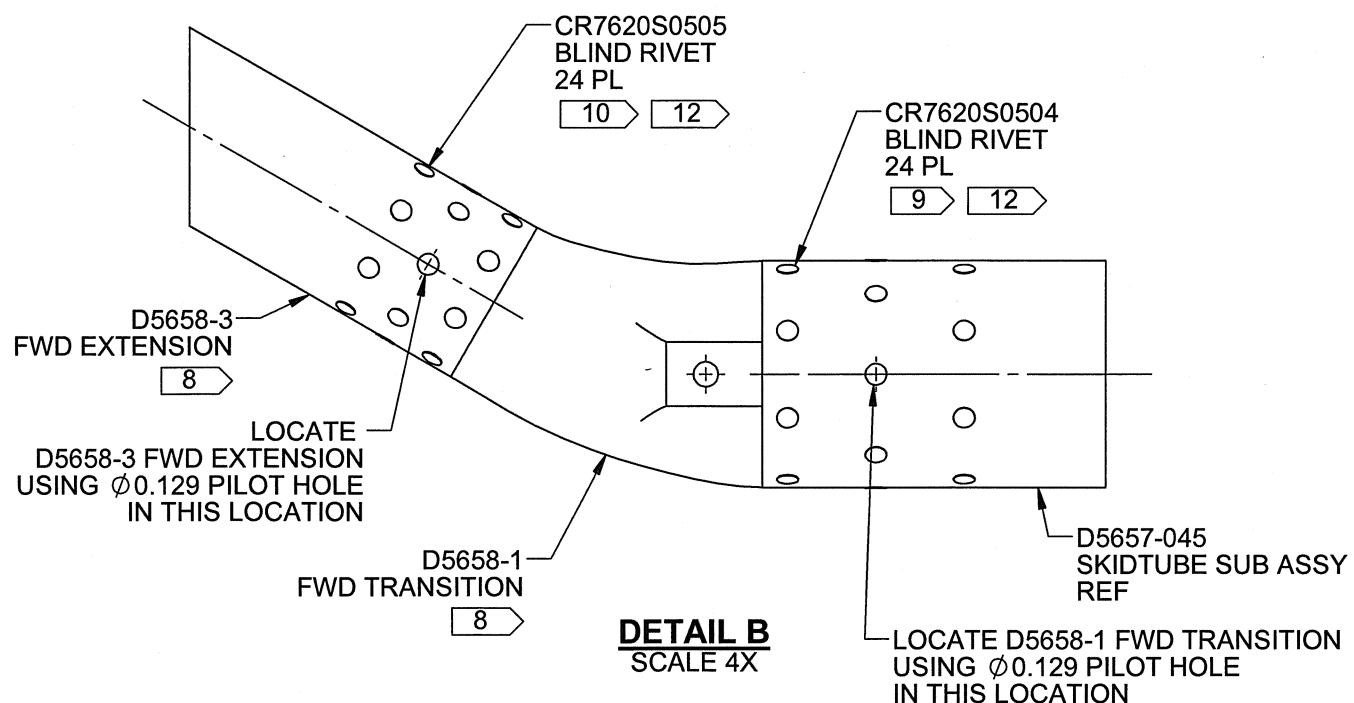
DRAWING NO. D5657 REV. A
SHEET 1 OF 6

TITLE SKIDTUBE
SCALE NTS

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QTY -043	P/N	DESCRIPTION
X	D5657-043	SKIDTUBE SUB ASSY
8	D4686-1	SPACER
16	D4753-1	DOUBLER
2	D5304-1	CROSSBOLT SPACER
2	D5534-3	HOSE SHIELD
1	D5657-045	SKIDTUBE SUB ASSY
1	D5658-1	FWD TRANSITION
1	D5658-3	FWD EXTENSION
4	AELS-1032-130	INSERT
4	AN3C4A	BOLT
4	CR1122-3-02.5	RIVET
6	CR3213-5-02	RIVET, CHERRY MAX
24	CR7620S0504	BLIND RIVET
24	CR7620S0505	BLIND RIVET
32	MS20601AD4W3	RIVET, BLIND, CSK
2	MS21048L4	NUTPLATE
4	NAS1149C0332R	WASHER



NOTES:
1) MATERIAL: N/A
2) FINISH: PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: NONE

7) WEIGHT: 36.9 lbs

8) SEAL FAYING SURFACES USING PROSEAL 890/1422 OR MIL-S-8802 SEALANT

9) TRANSFER DRILL QTY (24) Ø0.129 (#30 DRILL) HOLES FROM SKIDTUBE TO D5658-1 FWD TRANSITION
OPEN HOLES THRU SKIDTUBE AND D5658-1 FWD TRANSITION TO Ø0.164 / 0.167, COUNTERSINK THE SKIDTUBE HOLES TO Ø0.327 / 0.335 X 100°
DEBURR HOLES AND TOUCH-UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541

INSTALL D5658-1 FWD TRANSITION USING CR7620S0504 RIVETS

10) TRANSFER DRILL QTY (24) Ø0.129 (#30 DRILL) HOLES FROM D5658-3 FWD EXTENSION TO D5658-1 FWD TRANSITION
OPEN HOLES THRU D5658-3 FWD EXTENSION AND D5658-1 FWD TRANSITION TO Ø0.164 / 0.167
COUNTERSINK THE D5658-3 FWD EXTENSION HOLES TO Ø0.327 / 0.335 X 100°
DEBURR HOLES AND TOUCH-UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541

INSTALL D5658-3 FWD EXTENSION USING CR7620S0505 RIVETS.

11) LOCATE AND TRANSFER MARK HOLES FROM D5534-3 HOSE SHIELD TO SKIDTUBE. DRILL QTY (3) Ø0.161 HOLES THRU SKIDTUBE.
DEBURR HOLES AND TOUCH-UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541
INSTALL D5534-3 HOSE SHIELD AFTER FINISH WITH CR3213-5-02 RIVETS.

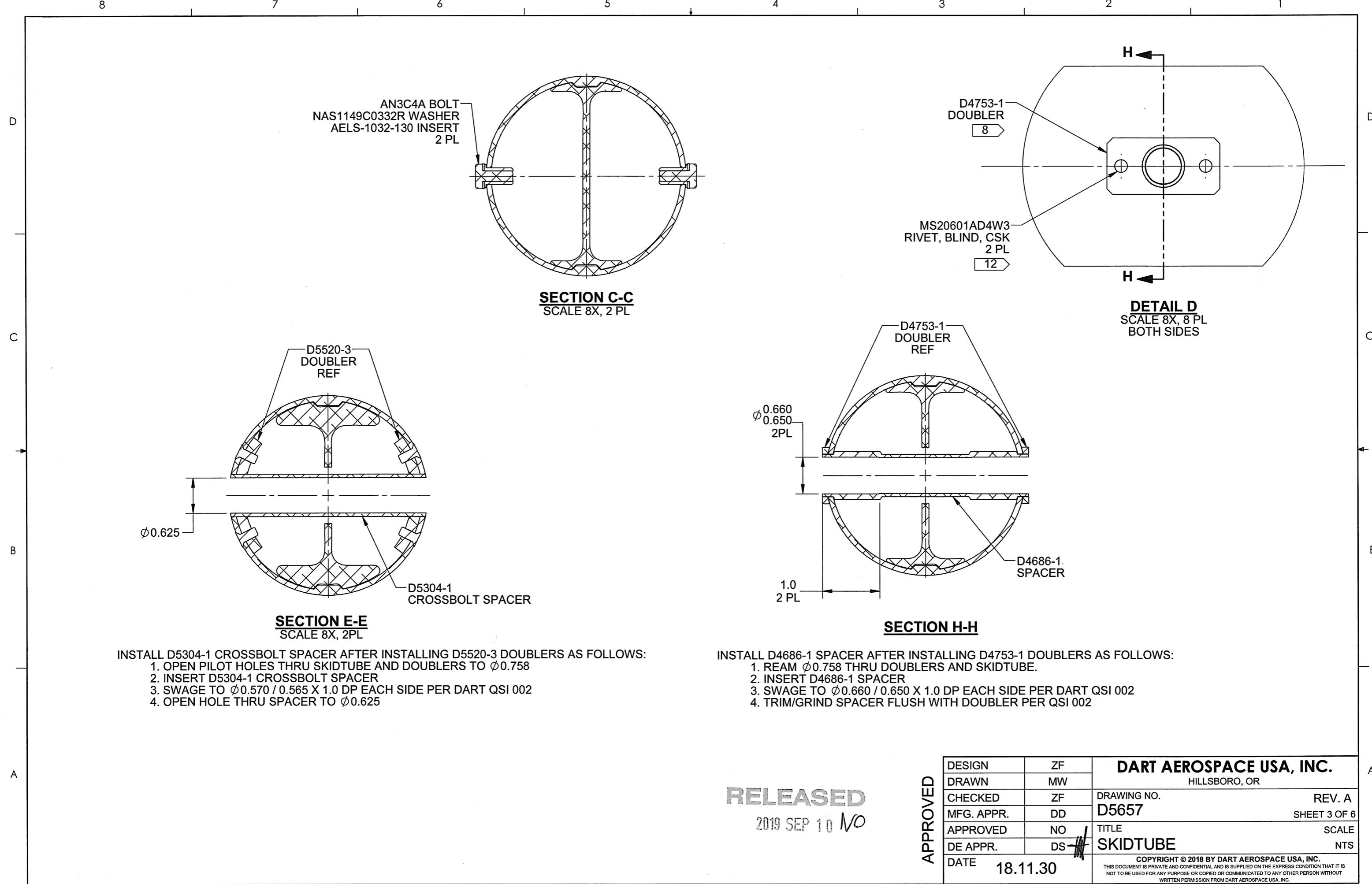
12) WET INSTALL RIVETS USING PROSEAL 890/1422 OR MIL-S-8802 SEALANT.

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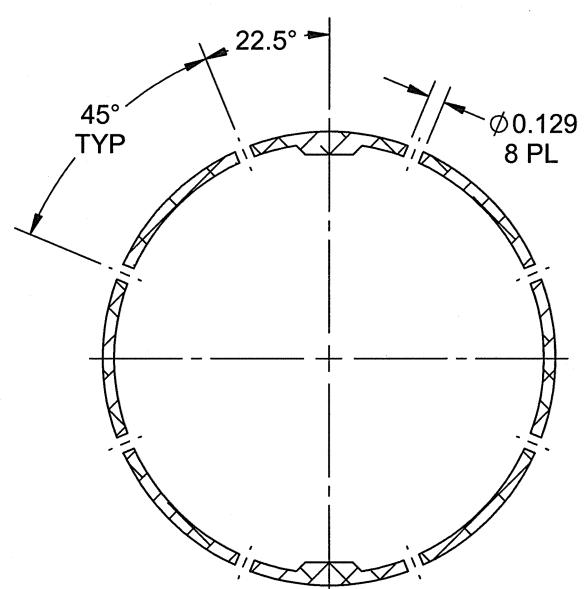
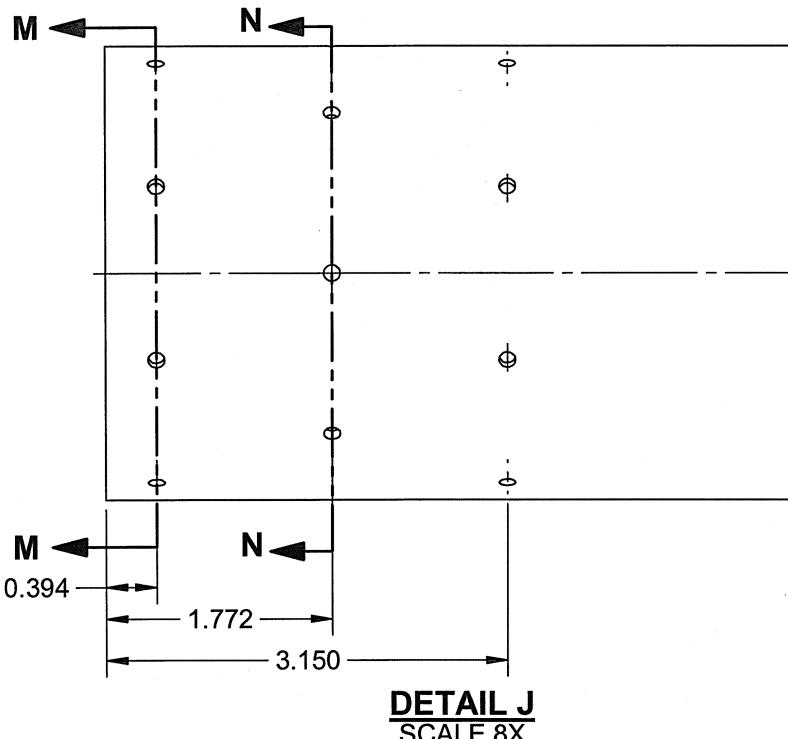
2019 SEP 10

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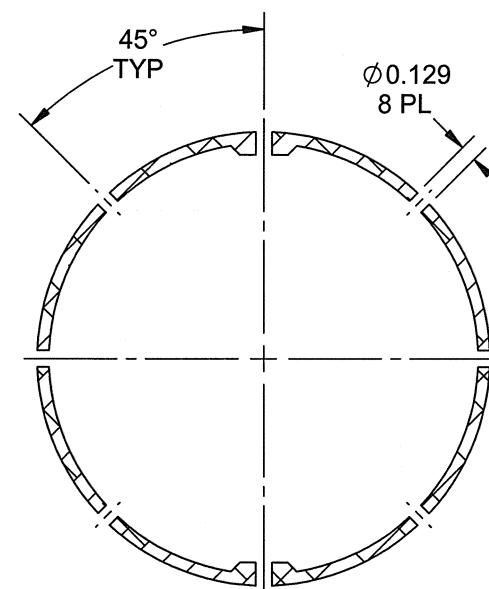
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DRAWN	MW	
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APPROVED	NO	
DE APPR.	DS	
TITLE	SKIDTUBE	SCALE NTS
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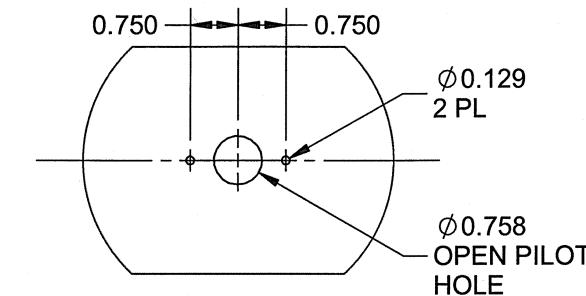
QTY -045	P/N	DESCRIPTION
X	D5657-045	SKIDTUBE SUB ASSY
1	D5657-1	SKIDTUBE
1	D5085-1	WEB
2	D5520-3	DOUBLER
60	CR3212-5-05	CSK RIVET, CHERRY MAX



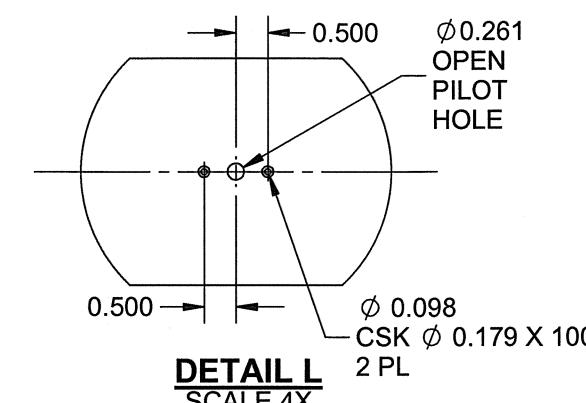
SECTION M-M
2 PL



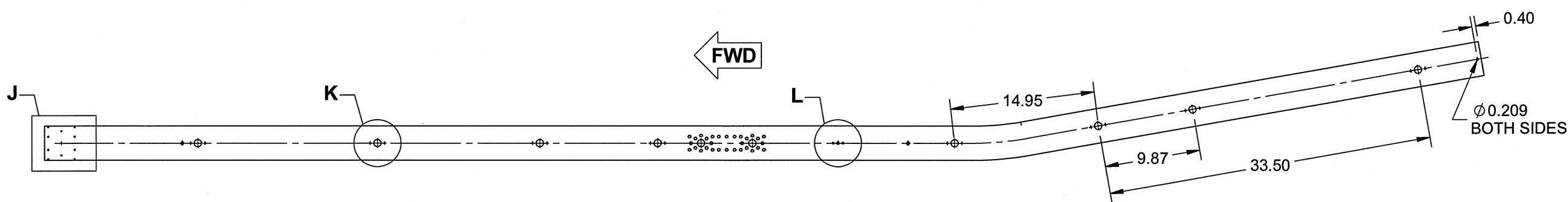
SECTION N-N



DETAIL K
SCALE 4X, 8 PL
BOTH SIDES



DETAIL L
SCALE 4X
BOTH SIDES



D5657-045 SKIDTUBE SUB ASSY
(DRILLING DETAIL)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 31.0 lbs

8) INSTALL WEB ASSY INTO SKIDTUBE WITH SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015, LOCATE AS SHOWN
 9) LOCATE THE D5520-3 DOUBLER USING THE $\phi 0.188$ PILOT HOLES IN THE SKIDTUBE AND DOUBLER
 10) DRILL QTY (30) $\phi 0.160$ / 0.164 (#20 DRILL) HOLES THRU SKIDTUBE AND D5520-3 DOUBLER USING TOOL DT 10481
 COUNTERSINK THE SKIDTUBE HOLES TO $\phi 0.283$ / $0.289 \times 100^\circ$
 DEBURR HOLES AND TOUCH-UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541
 INSTALL DOUBLER USING CR3212-5-05 RIVETS
 WET INSTALL RIVETS USING PROSEAL 890/1422 OR MIL-S-8802 SEALANT

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2019 SEP 10 No

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MFG. APPR.	DD
APPROVED	NO
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DART AEROSPACE USA, INC.
HILLSBORO, OR

REV. A
DRAWING NO.
D5657
SHEET 4 OF 6

SCALE
TITLE
SKIDTUBE
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